

# Work Order ID 63595

Thursday, November 04, 2010 1:05:27 PM



Page 1

Item ID:	D2143	Accept		Setup	Start	
Revisor ID:						
Item Name:	Hinge Bracket				Stop	
Start Date:	11/4/2010	Start Qty:	10.00			
Required Date:	11/25/2010	Req'd Qty:	10.00			
Reference:						

Approvals:	Process Plan:		Date:	10-11-04	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2143	Rev C1								

100		0.00							
	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
5052 - 240	1-Cut as per Dwg D2143 <input type="checkbox"/> Dwg Rev: C1 <input type="checkbox"/> Prog Rev: C1 <input type="checkbox"/> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

B10-11-30

19

B10-11-30

5010130

49

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63595**

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Item ID: D2143

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 11/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/25/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Tumble and Deburr

0.00

0.00

w/g 5

140



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D2143

0.00

0.00

SB 10/12/01

(19)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 10/12/01

(19)

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Start Date: 11/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/25/2010 Req'd Qty: 10.00

Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ M 10/12/02

19

Ø



HandFinish

Memo

0.00

Hand Finishing

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 11/5/01

19 BR 10-12-8.



Powdercoat

Memo

0.00

Powder Coating

START TIME:

9:30

□ OVEN TEMPERATURE:

320° □ FINISH TIME:

10:00

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 10 12 08 (19)

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Required Date: 11/25/2010 Req'd Qty: 10.00



Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: 198

0.00



Packaging

Memo

0.00

Packaging

11/12/10 Q90 [Signature]

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/09 [Signature]

MF

10-12-08

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# Picklist Print

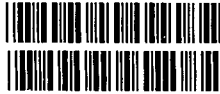
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Page 1

Work Order ID: 63595

Parent Item: D2143

Parent Item Name: Hinge Bracket



Start Date: 11/4/2010

Required Date: 11/15/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP ☐ C ☐ 00.05.18 ☐ Added inspection level 8 ☐ EC  
IPP Rev:D Now on WaterJet 06-10-15 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	32.3234	0.066	0.694737			

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT	23.8	
114488	23.8	
MAT23	8.5234	
101875	1.5	
109058	5.6234	
113123	1.4	

101875

19

11-11-30

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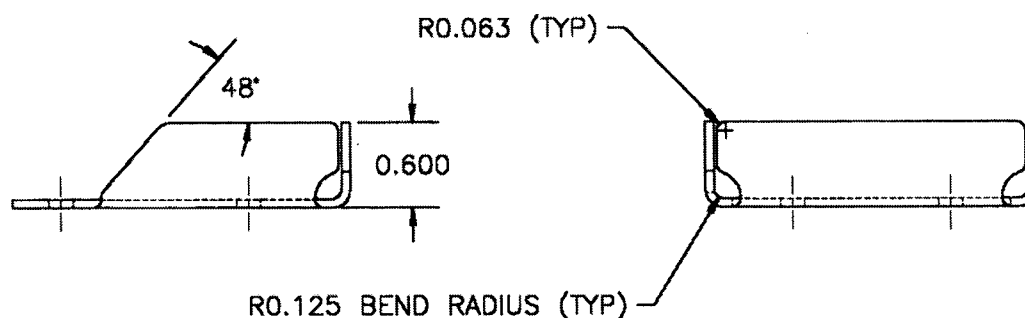
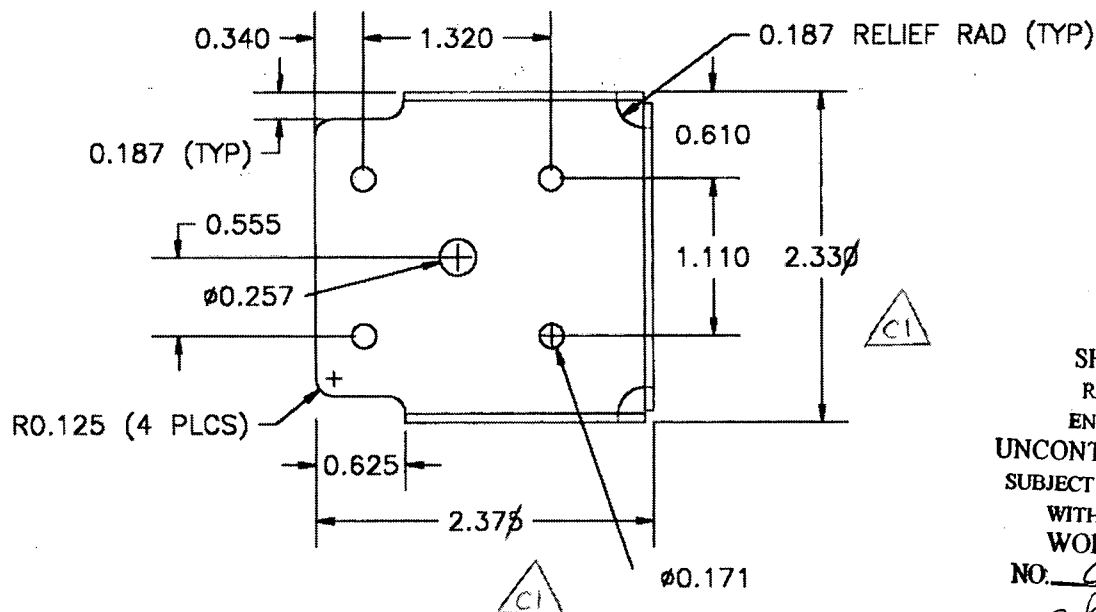
**NOTE:** Date & initial all entries



RELEASED  
960620 1503

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C
J BRADLEY	K HAND		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
BC	PH	D2143	
DATE		TITLE	SCALE
92.07.10		HINGE BRACKET	
B	96.06.06	ADD FLAT PATTERN	
C	96.06.13	MATERIAL WAS 2024-T3 .063 THICK	
CI	96.06.15	UPDATE DIMENSIONS	

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63595  
BS10-11-04



MATERIAL: 5052-H34, 0.040 THICK  
FINISH: WHITE POWDER COAT HI-GLOSS

W/O:		WORK ORDER CHANGES					
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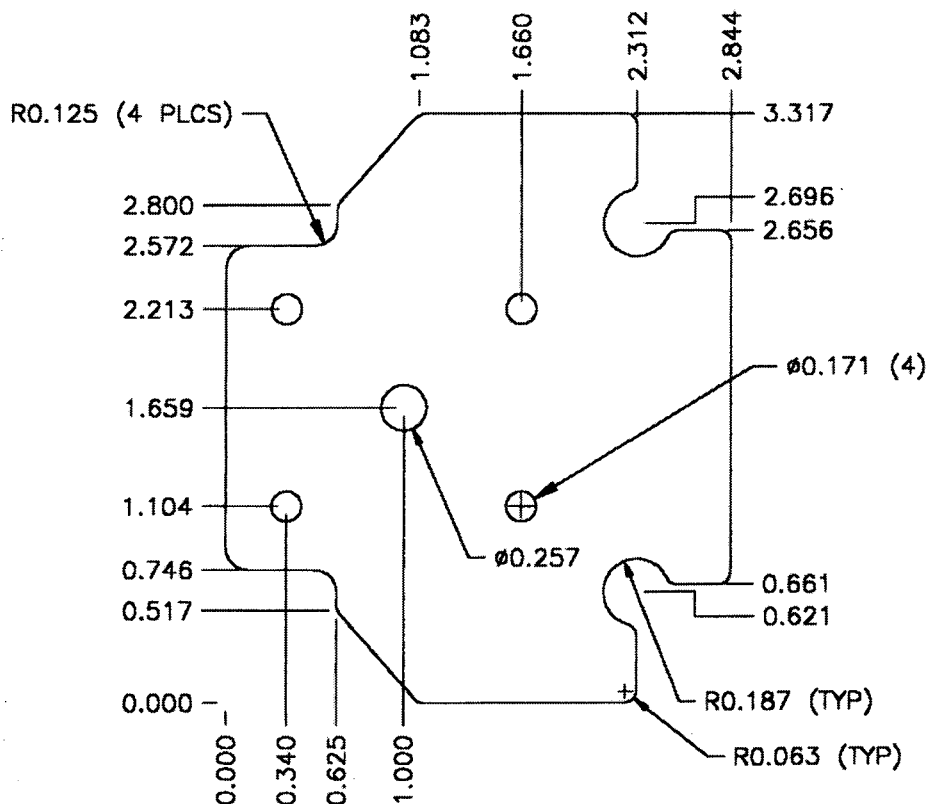
**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
J BRADLEY	K HAND	DRAWING NO.	REV. c
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2143	SHEET 2 OF 2
DATE	TITLE		SCALE
95:10:18	HINGE BRACKET FLAT PATTERN		1:1

RELEASED  
960620 BW

W/O 43595



MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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